












Date: Monday, 12/10/2007 12:04:15 PM
User: Kim Johnston




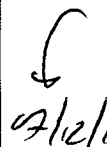



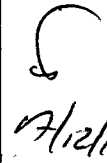
Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STRUT
Job Number : 36226	
Estimate Number : 12704	
P.O. Number : NIA	Part Number : D35501
This Issue : 12/10/2007 S.O. No. : NIA	Drawing Number : D3550 REV.B
Prsht Rev. : NC	Project Number : N/A
First Issue : NA	Drawing Revision : B
Previous Run : 32450	Material : NIA
Written By : <u> </u>	Due Date : 12/17/2007
Checked & Approved By : <u> </u>	Qty: <u>20</u> Um: <u>40</u> Each
Comment : Est. A 07.02.05 New issue EC	
Additional Product	
Job Number: 	
Seq. #:	Machine Or Operation: Description :
1.0	M304TR0500W049 304 RD Tube .500 x .049W
	 
Comment: Qty.: 1.7850 f(s)/Unit Total: 47.8500 f(s) <u>42.033</u> 304 RD Tube .500 x .049W 304/316 Seamless tubing 1/2" OD x .049 Wall Batch <u>M004862 SB 07/12/10</u>	
2.0	BRAKE NC NC BRAKE
	 
Comment: NC BRAKE 1-Form per Dwg D3550 <u>N18012</u> <u>SAD 07-12-18 19</u>	
3.0	SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1
	 
Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr if necessary. <u>SAD 07-12-18 19</u>	
4.0	QC5 INSPECT WORK TO CURRENT STEP
	  <u>X15</u>
Comment: INSPECT WORK TO CURRENT STEP <u>6 A/12/18</u>	
5.0	POWDER COATING POWDER COATING
	  <u>M105914</u>
Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3 <u>FL 07/12/19</u> <u>(5)</u>	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/12/18
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-12-18	2.0	One part scrap, didn't form correctly P.C. no jig for forming the flat END. Hand error		Scrap, destroy No replace made jig for forming flat END ON part	SAD 07-12-18 07/12/18			
07/12/18	2.0	Four (4) parts have the hole fl center by 0.000" to 0.000". P.C. Hammer/setup error		Scrap the four (4) parts. No replace	SAD 07-12-18 07/12/18			
				Total amount scrap is 45 on this work				

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 36226

Part Number: D35501

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



LL



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07-12-19

(X15)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 271

W

AS

07/12/19

(15)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/12/20

Job Completion



run 2007/12/20

U

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

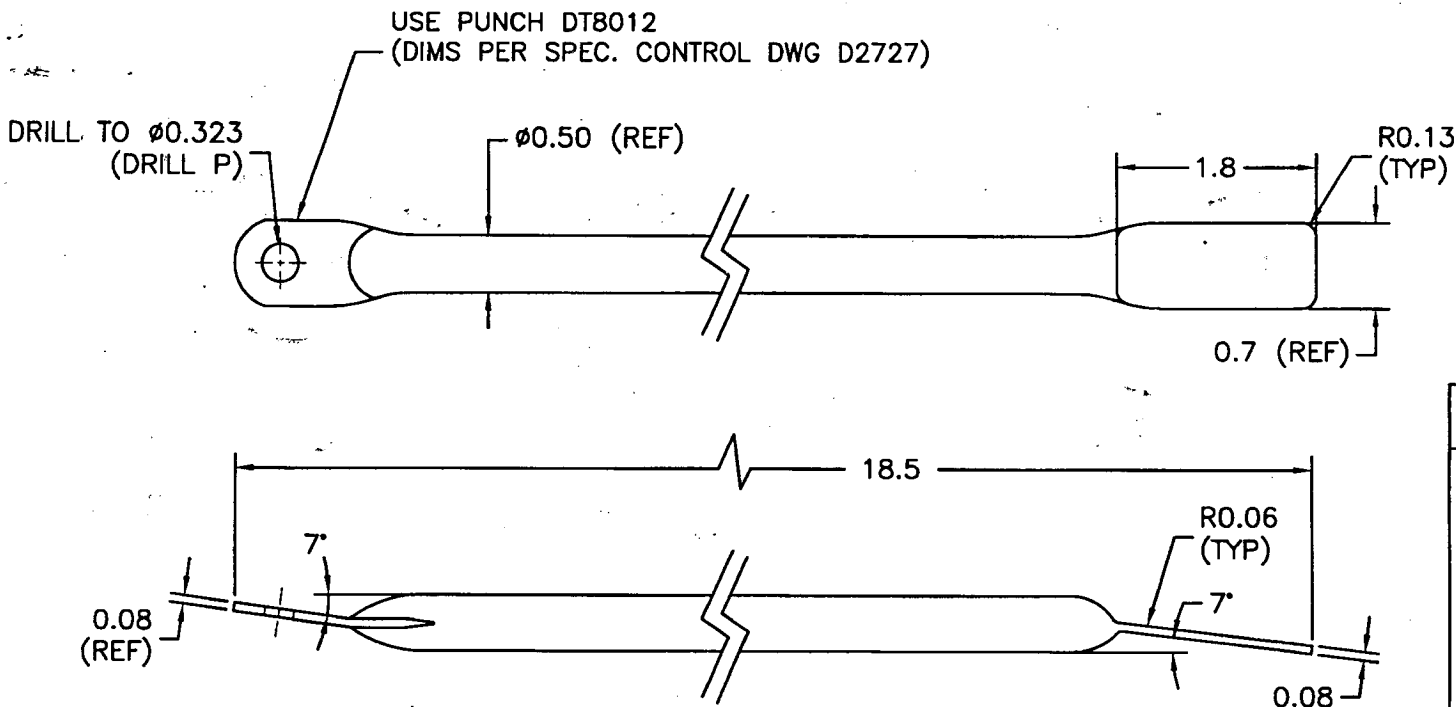
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CE	CE	DRAWING NO.	REV. B
CHECKED PH	APPROVED H	D3550	SHEET 1 OF 1
DATE 07.02.13	TITLE STRUT	SCALE NTS	
A	06.10.24	NEW ISSUE	
B	07.02.13	18.5 WAS 20.13; 1.8 WAS 1.5	



D3550-1 STRUT

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36226

NOTES:

- 1) MATERIAL: 304/316 SS SEAMLESS ROUND TUBE 0.500 OD X 0.049 WALL
(REF DART SPEC M304TR0.500W.049)
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) IDENTIFY WITH P/N D3550-1 USING FINE POINT PERMANENT INK MARKER

RELEASED
07.02.27